

**Dart Aerospace Ltd.**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARPAD		
<b>Job Number</b>	: 28699				
<b>Estimate Number</b>	: 11352				
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D33407		
<b>This Issue</b>	: 25/09/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b>	: D3340 REV B		
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A		
<b>First Issue</b>	: N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b>	: B		
<b>Previous Run</b>	: 28717	<b>Material</b>	: N/A		
<b>Written By</b>	: _____	<b>Due Date</b>	: 26/09/2006	<b>Qty:</b>	4 Um: Each
<b>Checked &amp; Approved By</b>	: _____				
<b>Comment</b>	: Est: A 05.11.10 Preliminary issue AP/EC Est Rev:B Now on Waterjet 06-09-25 JLM				

## Job Number:

1.0 M1010S20GA 1010/1025/A21/6aA SHEET

Batch: M101463

2.0 WATER JET FLOW WATER JET

Prog Rev: B

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

**Comment: SECOND CHECK**

5.0 BRAKE NC NC BRAKE

Deburr if necessary SAO 06:09:25 (4)  
Form on brake as per Dwg D3340 using Jigs DT and DT

Date: Monday, 25/09/2006 12:47:45 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28699

Part Number: D33407

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 43

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 06.09.27

*Rush-ship 27/09*

**Dart Aerospace Ltd.**

Date: Thursday, 9/21/2006 3:24:46 PM  
User: Kim Johnston

### Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARPAD
<b>Job Number</b> :	28699		
<b>Estimate Number</b> :	11352		
<b>P.O. Number</b> :		<b>Part Number</b> :	D33407
<b>This Issue</b> :	9/21/2006	<b>Drawing Number</b> :	D3340 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	25601	<b>Material</b> :	
<b>Written By</b> :	<i>9/20/06 09:21</i>		
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est: A 05.11.10 Preliminary issue AP/EC		

#### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-7

Material release note required

*11/05/2006  
8895F*

*Wetzel*

2.0	D33407F	Wearplate
-----	---------	-----------



**Comment:** Qty.: 1.0000 U(s)/Unit Total : 4.0000 U(s)  
Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



**Comment:** DIMENSIONAL CHECK

Inspect dimensions

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT and DT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: FD Date: 06/09/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:24:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28699

Part Number: D33407

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1206/09/26 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Y.L. -  
A.M. 06-09-26

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1206/09/27 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57363

1206/09/27 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1206/09/27 (4)

Job Completion



1206/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

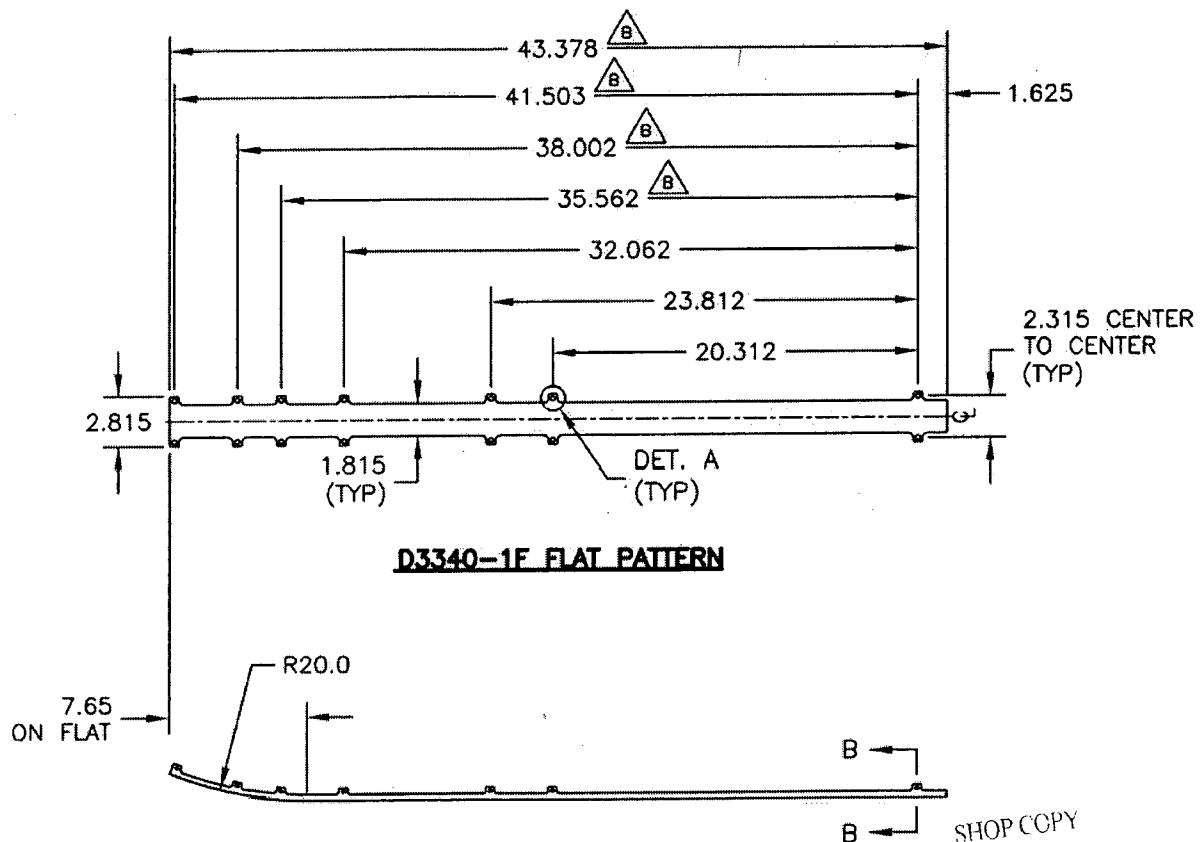
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

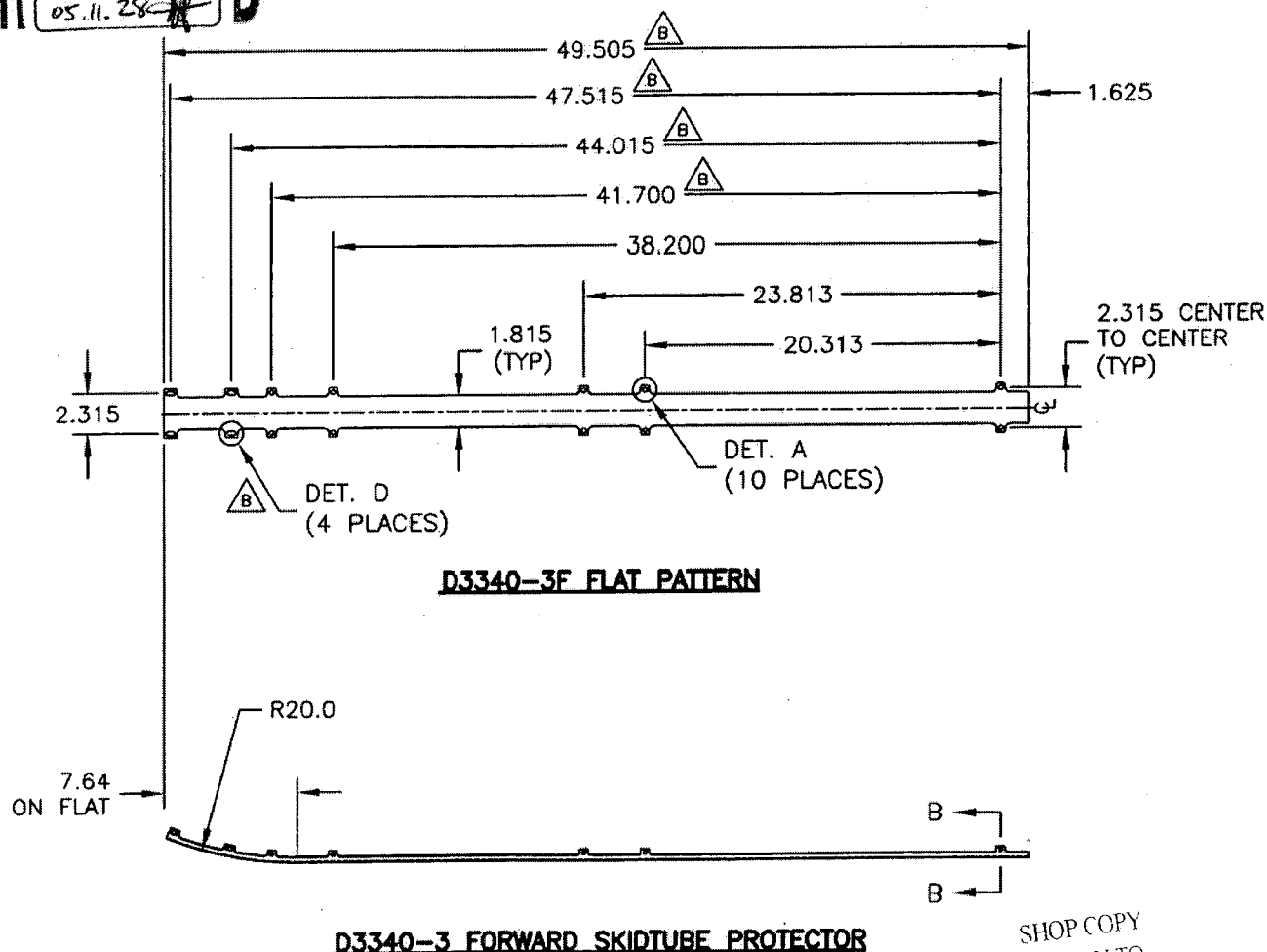
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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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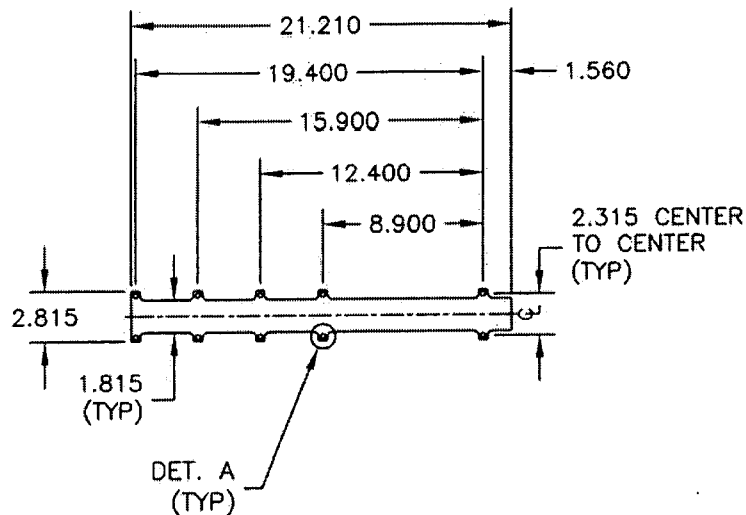
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

**RELEASED**  
05.11.28 ~~MB~~**D3340-5F FLAT PATTERN****D3340-5 FORWARD SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

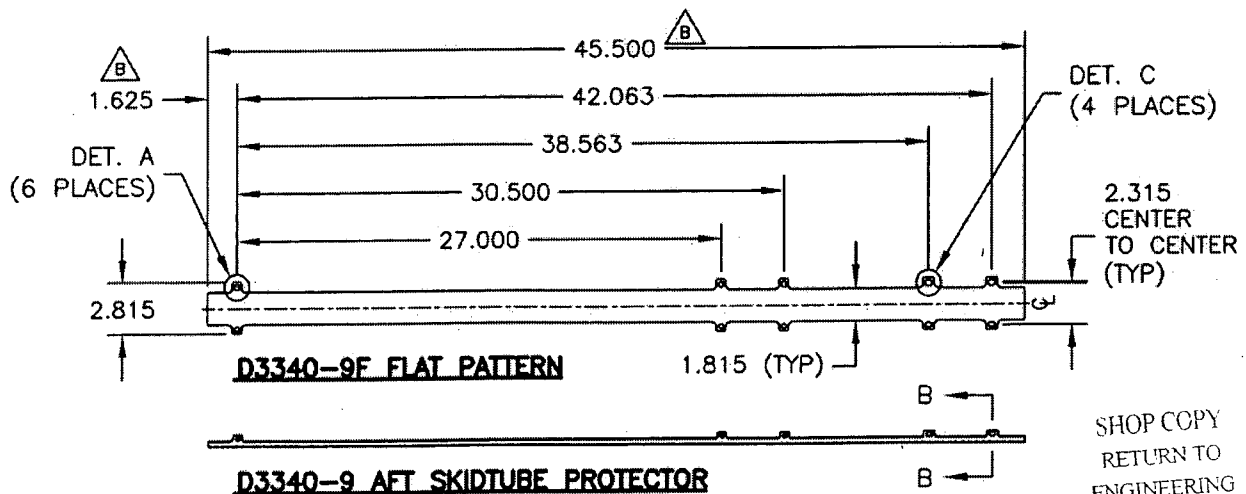
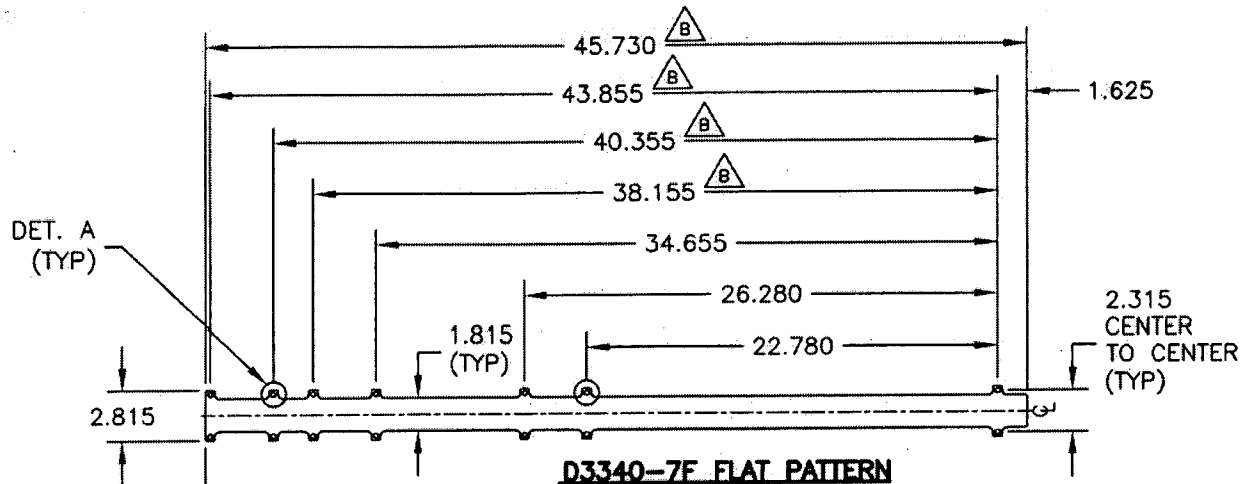
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
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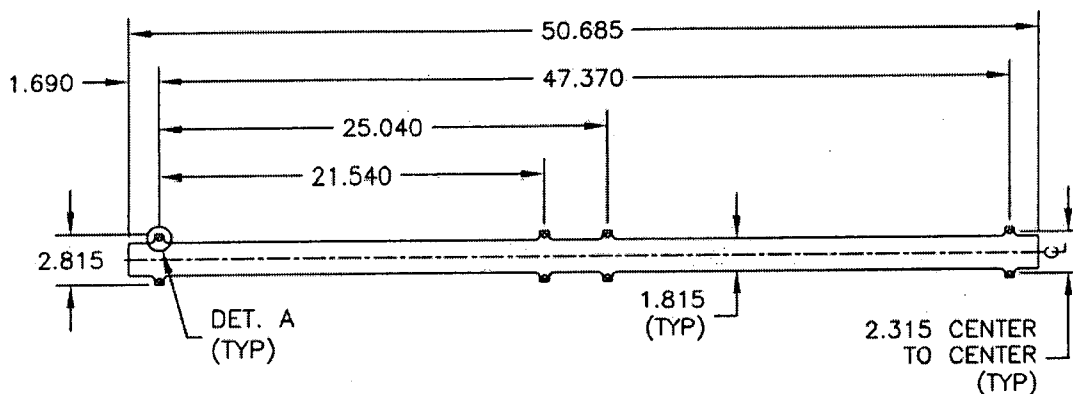
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**D3340-11F FLAT PATTERN**



**D3340-11 CENTER SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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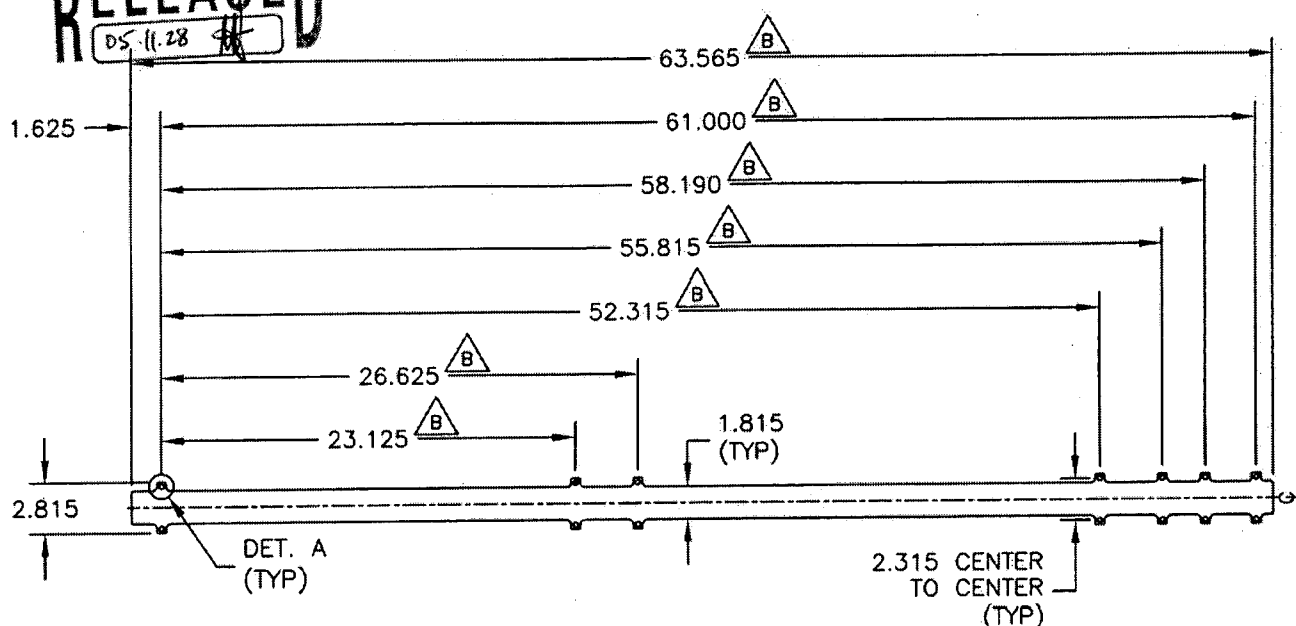
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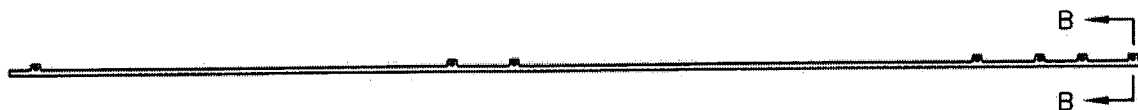


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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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**D3340-13F FLAT PATTERN**



**D3340-13 AFT SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

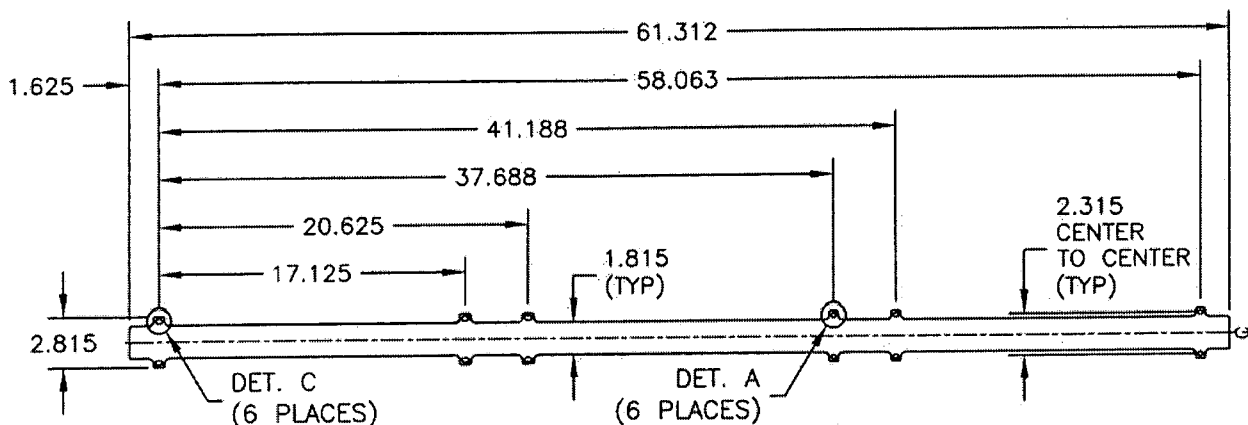
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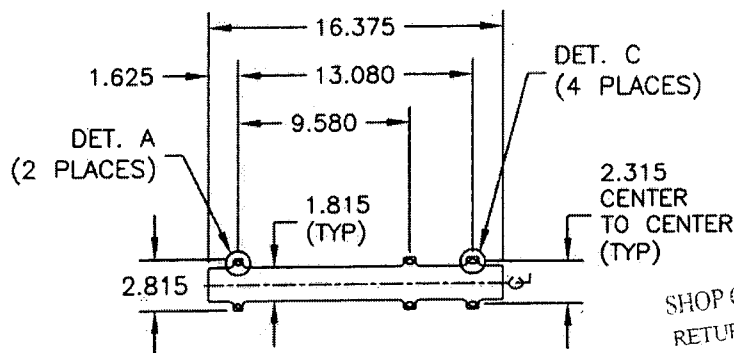
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**D3340-15F FLAT PATTERN**

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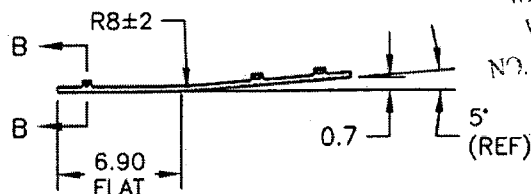
**D3340-15 CENTER SKIDTUBE PROTECTOR**



**D3340-17F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX





**D3340-17 AFT SKIDTUBE PROTECTOR**

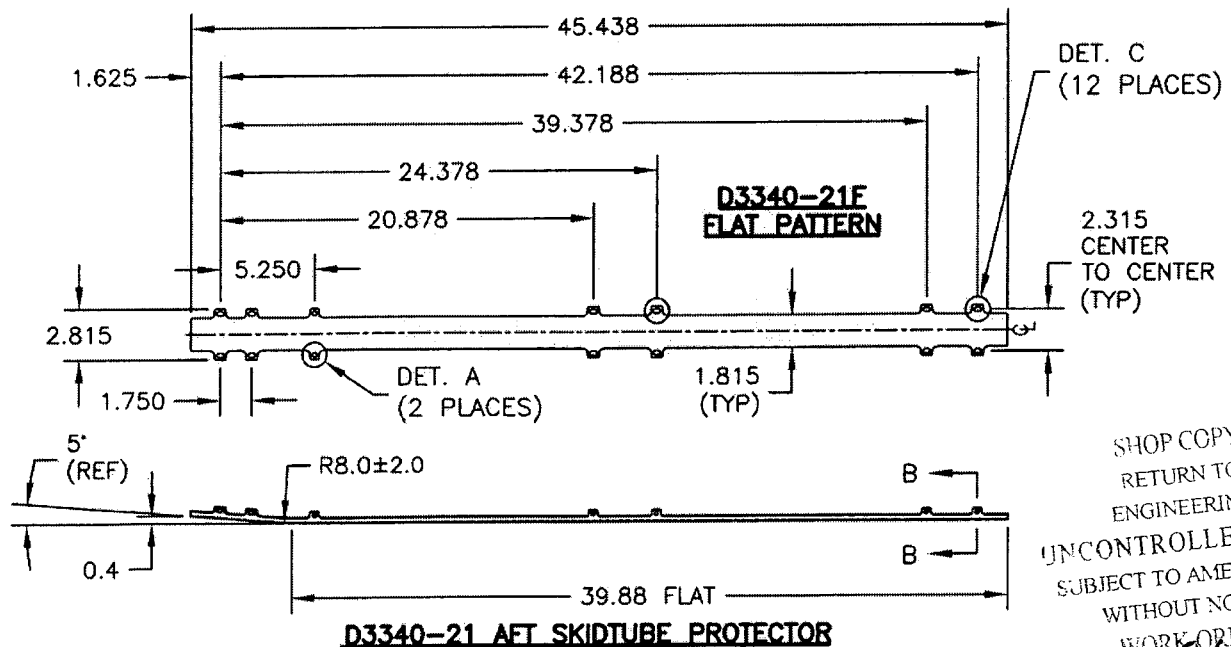
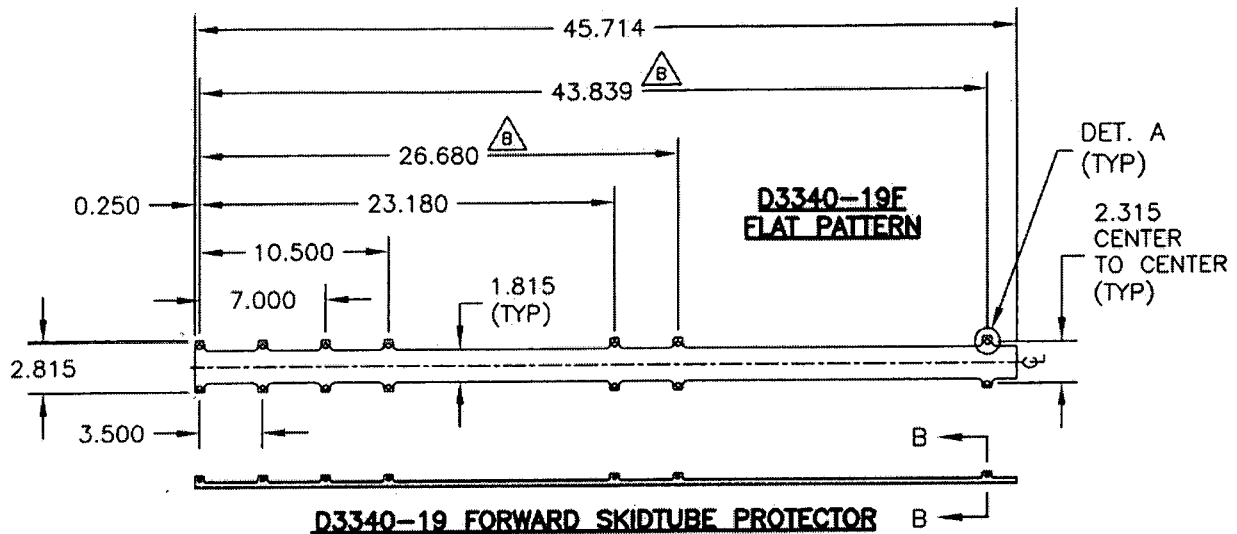
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



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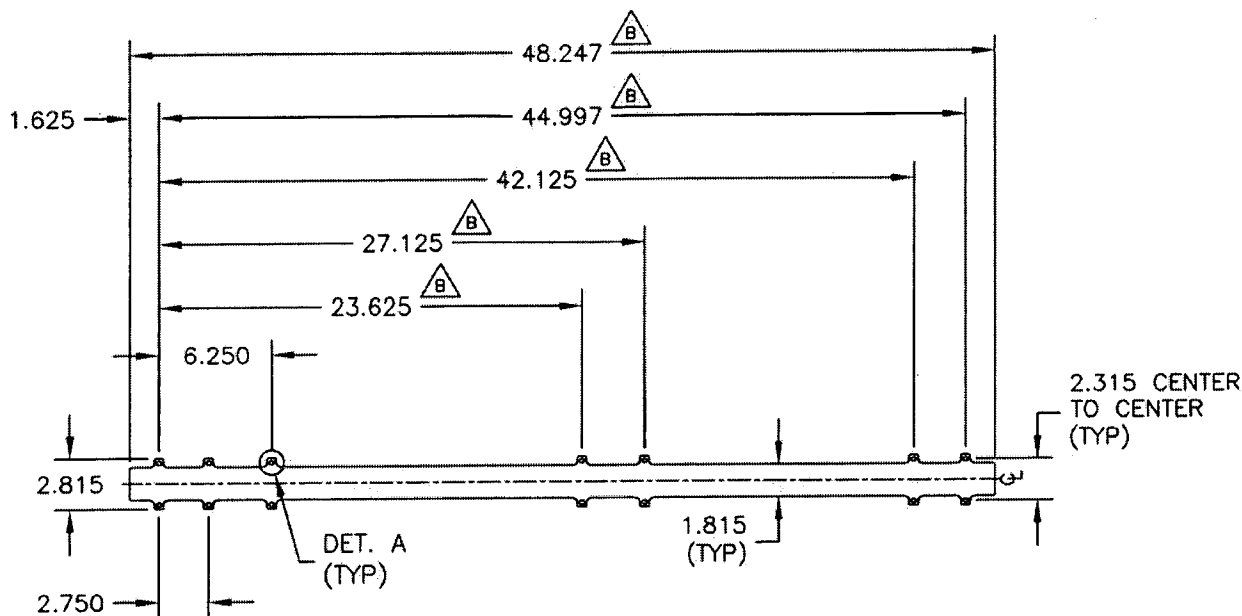
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- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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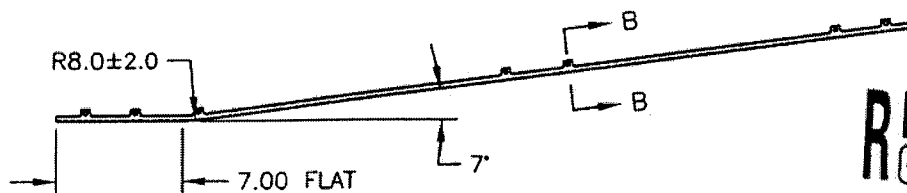
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**D3340-23F FLAT PATTERN**



**D3340-23 AFT FLOAT SKIDTUBE PROTECTOR**

**NOTES:**

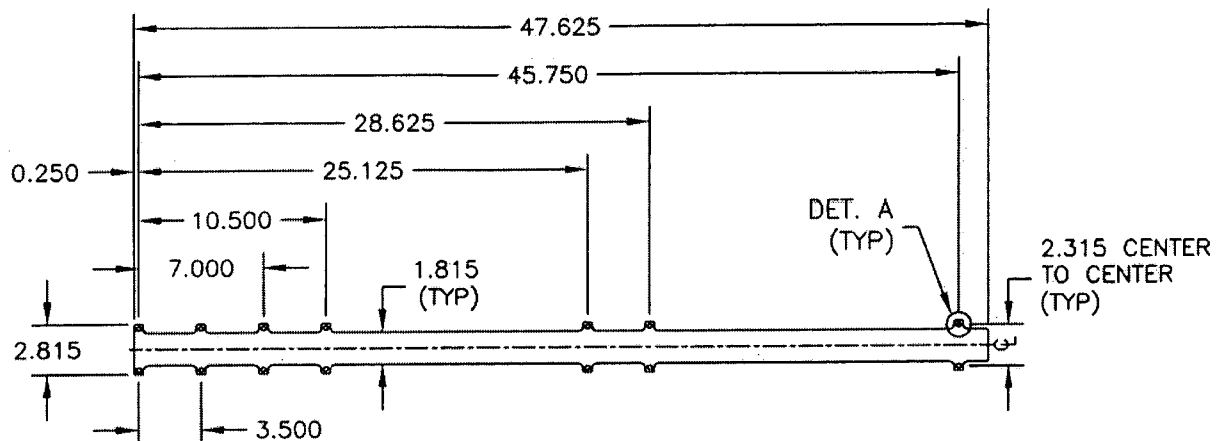
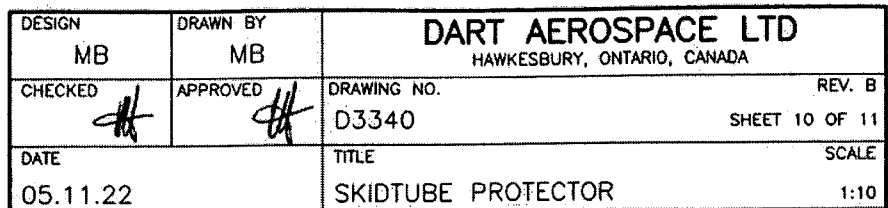
- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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**D3340-25F FLAT PATTERN**

RELEASED  
05-11-28



## D3340-25 FORWARD SKIDTUBE PROTECTOR

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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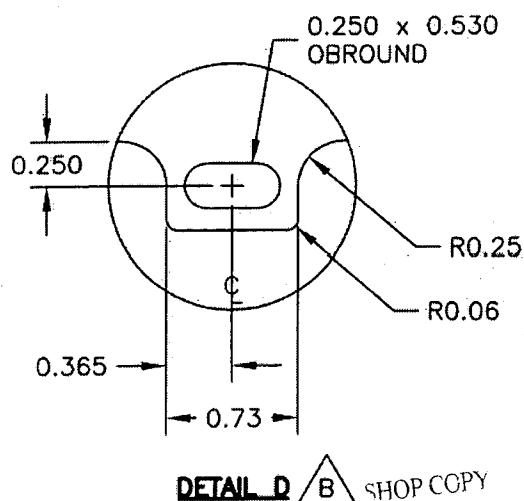
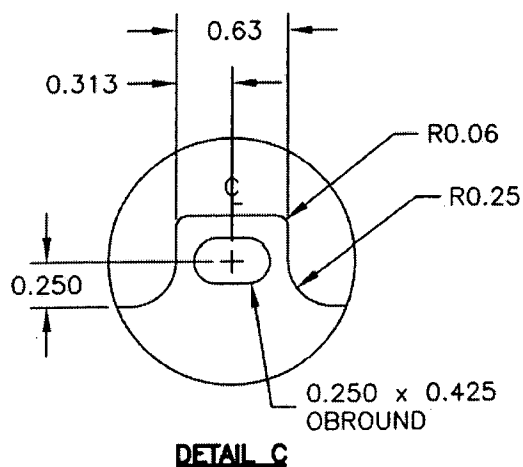
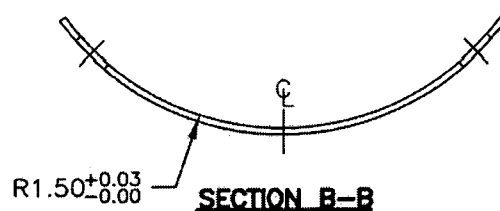
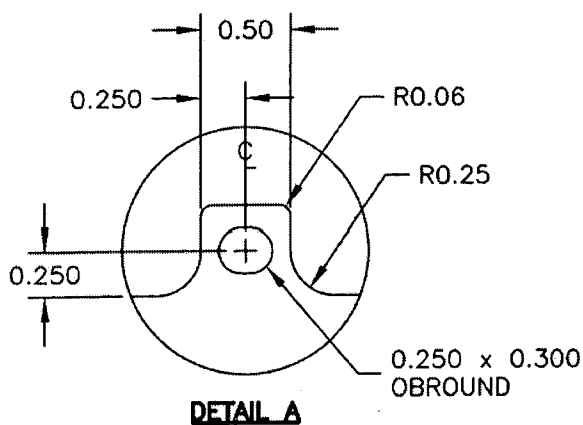
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